Work Order I			*1	N8 9	993*						Page 1
Item ID: D29 Revision ID: Item Name: Mou	957 unting Plate	(1°) *8*	Accept		*N900	040	100)* s	etup Star Stoj	ı V	S1*
Start Date: 10/3 Required Date: 11/0 Reference:	• /				Cust Item I Customer:	D:				IN.	
777 C	ocess Plan:	Date:	Tooling: SPC (Y/N):		nte:		R	un Star Stop	" \]	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2957	Rev B										
¹00 *1∩∩*	BAND SAW		0.00		JFC 201	3-11-0	7	10	Φ		
Bandsaw Jeaspa Bandsaw		ks 10.500" long makes 5 parts	0.00					2			
: ;;; * 410 *	HAAS CNC VERTIO	CAL MACHINING #1	0.00	0AS 44 2-89	13/11/11				d		
HAAS 1	Memo hine #1 Machine Deburr	e as per folio FA042	0.00	<i>5</i> 2,89	, , , , ,			_(()			
120	QC2- Inspect parts o	ff machine FAI/FAIB	0.00	: O AS					~		
120 QC Quality Control	Memo		0.00	44	13/11/11			(0)	<u> V</u>		

DQA:		Date	:		WORK ORDER NON-CONFORMANCE / UPDATE							``∂ART
QA Closed:		Date	:		WORK ORDER NON-	-C(ONFO	RMANCE / UPL		Vork Order u	odate only	AEROSPACE
					DISPOSITION					EPARTMENT		
Work Orde	er:					,			_	_	_	
D 1					Rework		Skid-tube Crosstube			_	Water Jet	Engineering
Part N	NO				Scrap			Machining	Small Fab	⊣	d. Eng. Coor.	Quality
NCR I	No.				Use-as-is Suspected Unapproved	1	inern	noforming Large Fab (Finishing	- Rec/Sto	re/Packaging	Other
NCN	···.				Suspected Onapproved	J		targe rab[Composite		Supplier	
Root				Desc	ption of work order update		Initial	Action	n	Sign &		
Cause	Da	te Step	Qty		or non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	QC Inspector
Design												
Doc/Data		1										
Equip/Tooling	Ш	ļ										
Handling/Pre		1										
Material						ļ						
Operator		ŀ								į		
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved	<u> </u>											
						FAI	ULT CA	TEGORY				
Landi	ng Gear			_	General		,		_			
	Bend	_		_	Bend		-	Program		Outside Dim	ensions	Pressure/Forced
		e Not Conc	entric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crack				Broken/Damage/Defect	_	Hardwa	are		Part Incorre	ct _	Temperature/Cure
	${f lack}$	/Kink/Ripp	le/Wave	L	Burrs	L	Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		4	tions Incomplete/Unc	lear	Part Moved	Ĺ	Wrong Stock Pulled
	Crush				Countersink	_	•	ned/off center		Positioned V		
	Heat				Cut Too Short	<u>_</u>	Mislabe	eled	L.	Power Loss/	Surge	Other
		ction Strip i	n Tube	<u> </u>	Drawing	_	Misread					
		s/Chatter			Drill Holes		Off-set					
		ng Sequenc			Finish	Out of Calibration						
	l lWave	/Twist in Tu	ibe	- 1	Fit/Function	1	Out of	Seguence				

Work Orde November-01-13				*108		Page 2					
Item ID: Revision ID: Item Name:	D2957 Mounting Pl	ata		Accept	*N900	<u>0401</u>	NN	* s	etup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:	10/31/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	ID:				IX	
Approvals:		lan:		Tooling: SPC (Y/N):		ate:		R	tun Sta Sto) T	R1* R2*
Sequence ID/ Work Center II 130 *120* QC Quality Control 150 *150* Packaging Packaging	D	Operation Description QC8- Inspect parts - second Memo Identify as per dwg & St Memo ******STOC		0.00	Tool ID	Tool# P	Code -	Accept Qty	Reject Qty DAS 28 9-89	Reject Number	Insp. Stamp
160 *160* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00			-		MUJ	1371-	13-11-12

DQA:		Date:			·			_						AART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		Wα	rk Order up	odate only		AEROSPACE
- 					DISPOSITION						PARTMENT		لسل	
Work Orde	er:			_		,			AGAINST		ANTONENT	7 NOCESS		
					Rework			Skid-tube	Crosstube			Water Jet	L	Engineering
Part N	No				Scrap		Machining Small Fab			Prod. Eng. Coor.			Quality	
					Use-as-is		Therr	noforming	Finishing		Rec/Stor	e/Packaging	$\overline{}$	Other
NCR I	No				Suspected Unapproved]		Large Fab	Composite			Supplier		
Root				Desci	ription of work order update		nitial	Act	ion		Sign &			
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	n	QC Inspector ·
Design														
Doc/Data										ŀ				
Equip/Tooling														
Handling/Pre	Ш		1									*		
Material	Ш									- 1				
Operator	Ш	1												
Offset/Setup	H					1								
Process	\vdash													
Supplier	H										-			
Training	H							-						
Transport Unapproved	H													
Onapproved	LI					EAL	IIIT CA	I TEGORY						
Landi	ng Gear				General	r A	OLI CA	ILGONT						<u> </u>
	Bendi	ng			Bend] Folio/F	Program	ſ		Outside Dim	ensions		Pressure/Forced
	_	e Not Conce	ntric		BOM/Route	\vdash	Grain			-	Over/Under			Set-up
	Crack				Broken/Damage/Defect		Hardwa	ire			Part Incorred		H	Temperature/Cure
	Crimp	/Kink/Ripple	e/Wave		Burrs		1	ion Incomplete/Un	ngualified	\dashv	Part Lost/Mi			Weld
	Cuffs				Contamination		1 '	ions Incomplete/U	· }	\dashv	Part Moved	O		Wrong Stock Pulled
	Crush	ing			Countersink	Г	4	ned/off center		\dashv	Positioned W	Vrong		
	Heat				Cut Too Short		Mislabe				Power Loss/	=		Other
	Inspe	ction Strip ir	1 Tube		Drawing		Misread	d	L		·	-		
	Mark	s/Chatter			Drill Holes		Off-set			•		· · · · · · · · · · · · · · · · · · ·		
	Turni	ng Sequence	2		Finish		Out of	Calibration		•				
	Wave	/Twist in Tu	he		Fit/Function	Г	Out of	Saguanca		•				

November-01-13 8:21:58 AM

Work Order ID: 108993

108993

Parent Item:

D2957

D2957

Parent Item Name: Mounting Plate

Start Date: 10/31/13

Required Date: 11/07/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: C00.08.09New dwg rev B (mpp 2078)EC

-Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6B0.500X01.25		Purchased	No			100	f	15.5000	0.175	2				

M6061T6B0 500X01 250

Location	Loc Qty	Loc Code		
MAT001	15.5			
122521	3.5		200 OFC	2013-11-07
m127095	. 12			·

**

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPI		ork Order up	odate only	AEROSPACE
QA Closed.			Date.		1								
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
	_				_	Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	•	ief Eng			Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material						!							
Operator													
Offset/Setup													
Process													
Supplier							ł						
Training													
Transport													
Unapproved												İ	
							FAI	ULT CA	TEGORY				
Landir	ng G	ear				General			•		_		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct 「	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Un	clear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	
		Heat Trea	ıt			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d	_	_		
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	158993
Description: Mounting Plate	Part Number:	D2957
Inspection Dwg: D2957 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype	Х	First A	rticle	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	. 24 9	7			
0.068	+/-0.010	820.	7			
Ø0.323	+/-0.010	<u>_</u> 323	7			
0.250	+/-0.010	.245	7			, , , , , , , , , , , , , , , , , , ,
1.06	+/-0.030	1.065				
0.875	+/-0.010	858.	7			
0.449	+/-0.010	,449	7			
R0.12	+/-0.030	.125	\			
1.85	+/-0.030	1.853	7			
0.250	+/-0.010	,24H	0			
0.19	+/-0.030	2581.			11-11-11-11-11-11-11-11-11-11-11-11-11-	· · · · · · · · · · · · · · · · · · ·
0.125	+/-0.010	152				

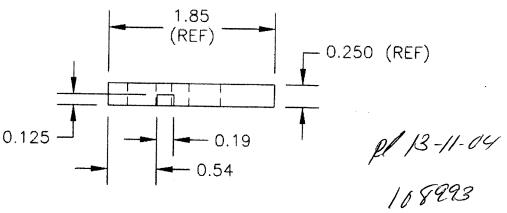
Measured by:	批	Audited by:	SL	Prototype Approval:	N/A
Date:	13/11/01	Date:	13-11-11	Date:	N/A

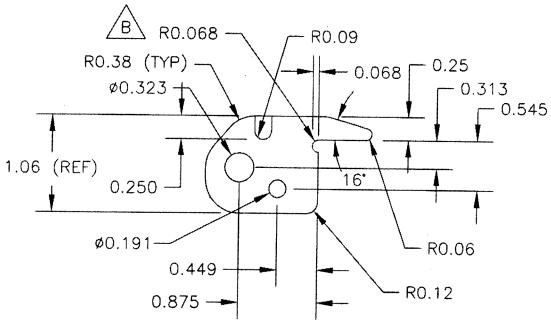
Rev	Date	Change	Revised, by	Approved
Α	04.04.20	New Issue	KJ/RF	14



	RF RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	APPROVED APPROVED	DRAWING NO. REV. B
DATE	<u> </u>	D2957 SHEET 1 OF 1
		TITLE SCALE
00.07.06		MOUNTING PLATE
Α	00.01.20	NEW ISSUE
В	00.07.06	MODIFY CORNER DETAIL

RELEASED (ac 07.12 4)





MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR

QQ-A-250/11) 0.250 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP EDGES 0.010 TO 0.020

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